

Date: Thursday, 1/24/2008 8:41:08 AM
 User: David Duval

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D205-541-044
Job Number	: 36906		
Estimate Number	: 10804		
P.O. Number	:	Part Number	: D205541044
This Issue	: 1/24/2008 S.O. No. :	Drawing Number	: D205-541
Prsht Rev.	: NC	Project Number	:
First Issue	: 1/1 Type: SMALL / MED FAB	Drawing Revision	:
Previous Run	: 00015	Material	:
Written By	: <i>[Signature]</i>	Due Date	: 1/30/2008 Qty: 1 Um: Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D205541044	Heli-Utility-Basket, RH
-----	------------	-------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Heli-Utility-Basket, RH

-Part was pulled and used for HAI

- D205-541-044 original B20305

ch 2.

08/01/04

2.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1

Dis-assemble all hardware on the basket, and discard

DO NOT discard the following D- parts:

- ✓ 2x D2022-101 B16709 spacer *B16709*
- ✓ 1x D2332-041 B20311 prop arm ass'y *B20311*
- ✓ 1x D2530 B18839 handle weldment
- ✓ 2x D2537 B19779 Bushing *B. 19779.*

Identify the above with the part, and original B#, for use on re-assembly.

08-01-30 (40)

3.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

- smooth out all affected area's on the base and lid.

X-A 2530
Handle weldment

08-01-30 (41)

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

-1 lid
-1 base
08/01/30 (41)
















Date: Thursday, 1/24/2008 8:41:09 AM
User: David Duval

Process Sheet

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Customer: CC-DAR01 Dart Aerospace Ltd.		Drawing Name: D205-541-044	
Job Number: 36906		Part Number: D205541044	
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
			
Comment: HAND FINISHING RESOURCE #1			
<p>Re-powder coat white per QSI005 4.3.5.2 => M106379 w/ 08-01-31 (x1) FL 08/01/31 ① - Spray paint black, and wing walk as per DWG. Spray paint - m106925 ww - m106332</p>			
6.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION	
			
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION mf 08-01-31. ①			
7.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
			
Comment: SMALL & MEDIUM FAB RESOURCE 1			
Pick the following. mf 08-01-31. ①			
8.0	D2258300	Placard	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)			
Placard			
Batch: B 28072 mf			
9.0	D2535	Spring	
			
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)			
Spring			
Batch: B34590 mf			
10.0	D2931	Bumper	
			
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)			
Bumper			
Batch: 21139 mf			
11.0	AN316A	Bolt	
			
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)			
Bolt			
Batch: m104603 mf 08-01-31			

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D205-541-044

Job Number: 36906

Part Number: D205541044

Job Number:



Seq. #:	Machine Or Operation:	Description :
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40.0	AN513A	Bolt
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: 104936

AS

08/02/01

(X1)

41.0	AN960JD416	Washer
------	------------	--------



Comment: Qty.: 29.0000 Each(s)/Unit Total : 29.0000 Each(s)

Washer

106780

AS

08/02/01

(X1)

42.0	AN960JD516	Washer
------	------------	--------



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Washer

Batch: M106167

AS

08/02/01

(X1)

43.0	MS21042L4	Nut
------	-----------	-----



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Nut

Batch: M105938

AS

08/02/01

(X1)

44.0	MS21042L5	Nut
------	-----------	-----



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch: 105940

AS

08/02/01

(X1)

45.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

08/02/01

46.0	PACKAGING 1	PACKAGING RESOURCE #1
------	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-541-044

Location:

PPP Rev:

08/02/01

Date: Thursday, 1/24/2008 8:41:09 AM

User: David Duval

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D205-541-044

Job Number: 36906

Part Number: D205541044

Job Number:



Seq. #:

Machine Or Operation:

Description :

47.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

D205541044/06

Job Completion



le 08/02/05

5. PARTS LIST

REFERENCE ONLY

Qty -043	Qty -044	Part Number	Description
X		D205-541-043	HELI-UTILITY-BASKET LH
	X	D205-541-044	HELI-UTILITY-BASKET RH
2	2	D2022-104	SPACER
1	1	D2199-1	STRUT
1	1	D2199-23	STRUT
1	1	D2199-25	STRUT
1	1	D2258-300	LABEL
1	1	D2332-041	PROP ASSEMBLY
1	1	D2498	MOUNTING LUG
1	1	D2499	MOUNTING LUG
1	1	D2512	BASKET LID ASSEMBLY
2	2	D2530	BUSHING
1	1	D2530	HANDLE ASSEMBLY
2	2	D2535	SPRING
2	2	D2537	BUSHING
2	2	D2931	BUMPER
1	1	D3052-1	MOUNTING LUG
1		D3053-041	BASKET BASE ASSEMBLY, LH
	1	D3053-042	BASKET BASE ASSEMBLY, RH
1	1	* D2446	* SIGN PLATE
1	1	* D2509	* LINER (BASE)
1	1	* D2511	* LINER (END)
2	2	AN3-16A	BOLT
4	4	AN4-7A	BOLT
3	3	AN4-12A	BOLT
9	9	AN4-13A	BOLT
2	2	AN4-14A	BOLT
1	1	AN4-22A	BOLT
1	1	AN4-24A	BOLT
1	1	AN5-7A	BOLT
1	1	AN5-13A	BOLT
4	4	AN5-17A	BOLT
30	30	AN960JD416	WASHER
7	7	AN960JD516	WASHER
2	2	AN960JD8	WASHER
4	4	AN970-4	WASHER
2	2	MS20600AD4W3	RIVET
2	2	MS21042L3	NUT (OR MS21042-3)
20	20	MS21042L4	NUT (OR MS21042-4)
6	6	MS21042L5	NUT (OR MS21042-5)
6	6	* MS24693S272	* SCREW
6	6	* A3235-020-935	* WASHER
6	6	* NAS679A3W	* NUT
4	4	* MS20470AD4-8	* RIVET
42	42	* MS20600AD4W4	* RIVET

* OPTIONAL EQUIPMENT

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Revision: F

Date: 06.04.19

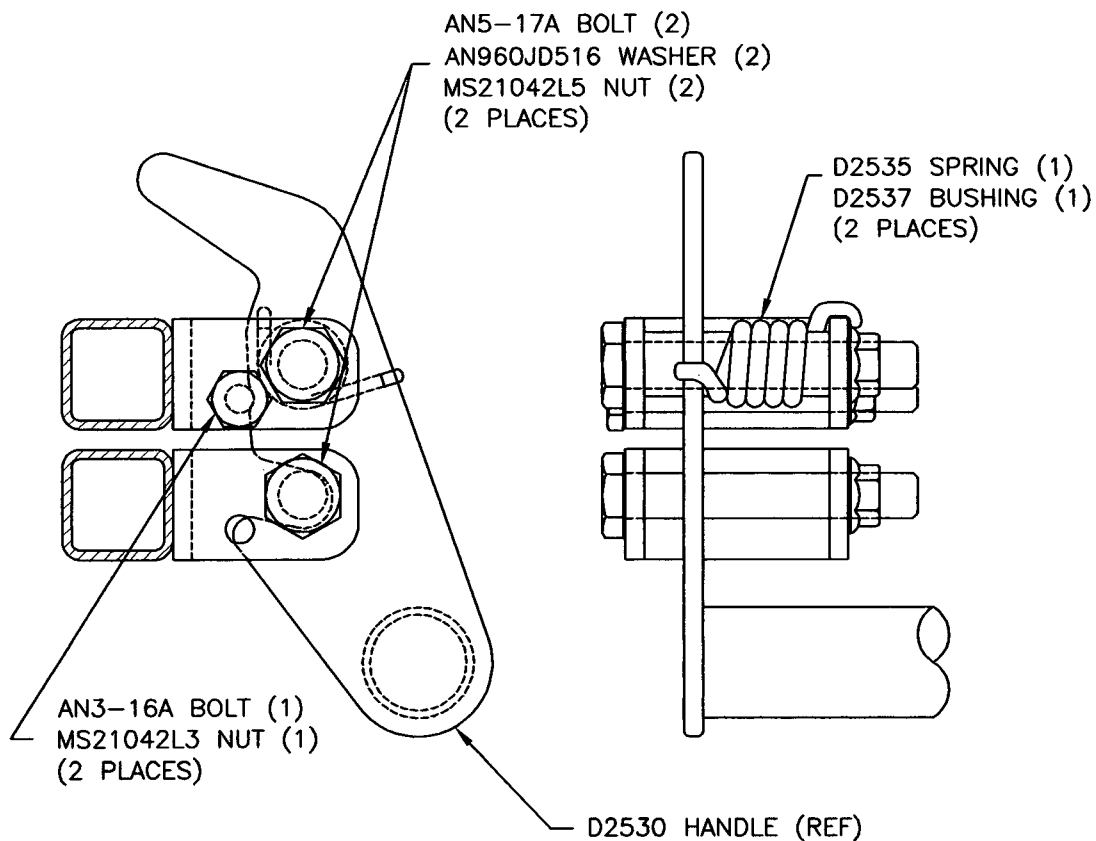


Figure 8 – Detail H Handle Assembly.

4. WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-541-043 <i>Heli-Utility-Basket™</i>	118 lb 53.6 kg	- 63.13 in - 1.60 m	- 7449 in-lb - 85.8 m-kg	132.25 in 3.36 m	15606 in-lb 180.1 m-kg
D205-541-044 <i>Heli-Utility-Basket™</i>	118 lb 53.6 kg	+ 63.13 in + 1.60 m	+ 7449 in-lb + 85.8 m-kg	132.25 in 3.36 m	15606 in-lb 180.1 m-kg

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Revision: **F**
Date: 06.04.19

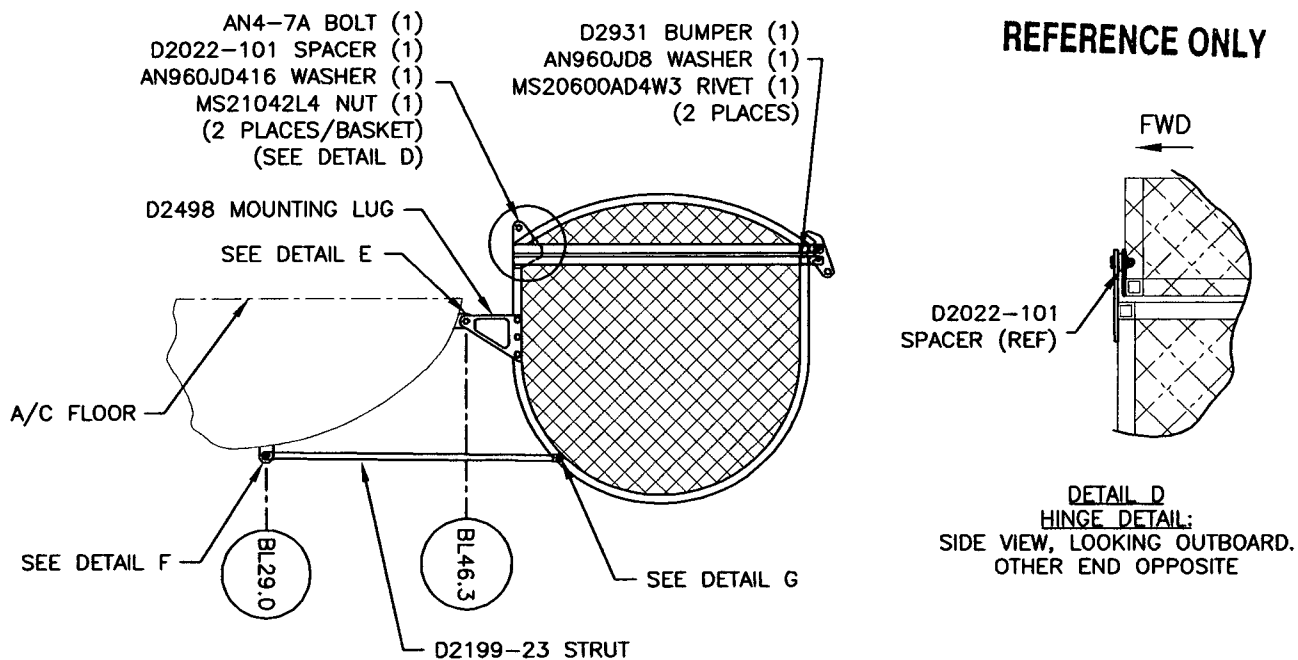


Figure 25-2 – Section A-A Looking Fwd at STA 84.29
(D205-541-044 Shown. D205-541-043 Opposite)

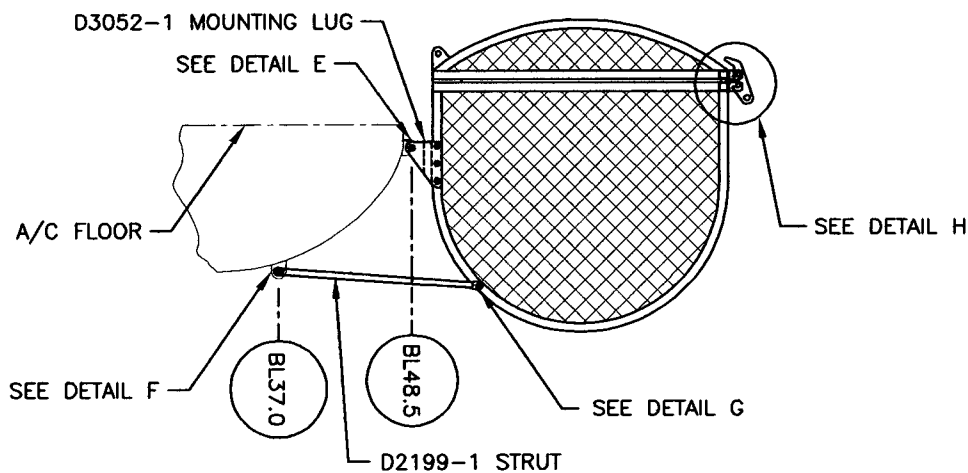


Figure 25-3 – Section B-B Looking Fwd at STA 129.00
(D205-541-044 Shown. D205-541-043 Opposite)

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25-00-00

DART AEROSPACE LTD	Work Order:	20305
Description: HELI-UTILITY-BASKET, RH	Part Number:	D205-541-044
Drawing: D205-541 Rev. E DSI 9131	Qty:	1
Page 1 of 2		

Step	Location	Procedure	By	Date	Qty																																																																																																																																																																
1	DC	Issue Travellers for: D205-541-044 Utility-Basket, RH D3053-042 Base D2512 Lid Drawing not required	Batch 20305 20305 20305 HJ	04.02.02	1																																																																																																																																																																
2	DC	Photocopy bluefile and type labels per PPP D205-541-044 CHG002	UK 7 HJ	04.02.13	1																																																																																																																																																																
3	WS	Go to traveler D3053-042 & D2512	AS	04/02/26	1																																																																																																																																																																
4	KP	Pick: Assembly Kit <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>2</td><td>D2022-101</td><td>Spacer</td><td>B16709</td></tr><tr><td>1</td><td>D2258-300</td><td>Label</td><td>B16384</td></tr><tr><td>1</td><td>D2332-041</td><td>Prop Ass'y</td><td>B20311</td></tr><tr><td>1</td><td>D2530</td><td>Handle Ass'y</td><td>B18839</td></tr><tr><td>2</td><td>D2535</td><td>Spring</td><td>B19424</td></tr><tr><td>2</td><td>D2537</td><td>Bushing</td><td>B19779</td></tr><tr><td>2</td><td>D2931</td><td>Bumper</td><td>B19972</td></tr><tr><td>2</td><td>AN3-16A</td><td>Bolt</td><td>M14040</td></tr><tr><td>2</td><td>AN4-7A</td><td>Bolt</td><td>M14291</td></tr><tr><td>1</td><td>AN4-22A</td><td>Bolt</td><td>M12490</td></tr><tr><td>1</td><td>AN4-24A</td><td>Bolt</td><td>M14149</td></tr><tr><td>4</td><td>AN5-17A</td><td>Bolt</td><td>M14393</td></tr><tr><td>2</td><td>AN960JD416</td><td>Washer</td><td>M13719</td></tr><tr><td>2</td><td>AN960JD416L</td><td>Washer</td><td>M3154</td></tr><tr><td>4</td><td>AN960JD516</td><td>Washer</td><td>M13767</td></tr><tr><td>2</td><td>AN960JD8</td><td>Washer</td><td>M9636</td></tr><tr><td>4</td><td>AN970-4</td><td>Washer</td><td>M14041</td></tr><tr><td>2</td><td>MS21042L3</td><td>Nut (or -3)</td><td>M14019</td></tr><tr><td>4</td><td>MS21042L4</td><td>Nut (or -4)</td><td>M13276</td></tr><tr><td>4</td><td>MS21042L5</td><td>Nut (or -5)</td><td>M5289</td></tr><tr><td>2</td><td>MS20600AD4W3</td><td>Rivet</td><td>M13658</td></tr></table> Pick: Packing Kit <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D2199-1</td><td>Strut</td><td>B19856</td></tr><tr><td>1</td><td>D2199-23</td><td>Strut</td><td>B12793/B11406/B10730</td></tr><tr><td>1</td><td>D2199-25</td><td>Strut</td><td>B12794</td></tr><tr><td>1</td><td>D2498</td><td>Mounting lug</td><td>B3924</td></tr><tr><td>1</td><td>D2499</td><td>Mounting lug</td><td>B1769</td></tr><tr><td>2</td><td>D2515</td><td>Bushing</td><td>B18029</td></tr><tr><td>1</td><td>D3052-1</td><td>Mounting lug</td><td>B18143</td></tr><tr><td>2</td><td>AN4-7A</td><td>Bolt</td><td>M14291</td></tr><tr><td>3</td><td>AN4-12A</td><td>Bolt</td><td>M13654</td></tr><tr><td>9</td><td>AN4-13A</td><td>Bolt</td><td>M14237</td></tr><tr><td>2</td><td>AN4-14A</td><td>Bolt</td><td>M13103</td></tr><tr><td>1</td><td>AN5-7A</td><td>Bolt</td><td>M5760</td></tr><tr><td>1</td><td>AN5-13A</td><td>Bolt</td><td>M13237</td></tr><tr><td>29</td><td>AN960JD416</td><td>Washer</td><td>M13719</td></tr><tr><td>3</td><td>AN960JD516</td><td>Washer</td><td>M13767</td></tr><tr><td>16</td><td>MS21042L4</td><td>Nut (or -4)</td><td>M13276</td></tr><tr><td>2</td><td>MS21042L5</td><td>Nut (or -5)</td><td>M5289</td></tr></table>	Qty	Part Number	Description	Batch	2	D2022-101	Spacer	B16709	1	D2258-300	Label	B16384	1	D2332-041	Prop Ass'y	B20311	1	D2530	Handle Ass'y	B18839	2	D2535	Spring	B19424	2	D2537	Bushing	B19779	2	D2931	Bumper	B19972	2	AN3-16A	Bolt	M14040	2	AN4-7A	Bolt	M14291	1	AN4-22A	Bolt	M12490	1	AN4-24A	Bolt	M14149	4	AN5-17A	Bolt	M14393	2	AN960JD416	Washer	M13719	2	AN960JD416L	Washer	M3154	4	AN960JD516	Washer	M13767	2	AN960JD8	Washer	M9636	4	AN970-4	Washer	M14041	2	MS21042L3	Nut (or -3)	M14019	4	MS21042L4	Nut (or -4)	M13276	4	MS21042L5	Nut (or -5)	M5289	2	MS20600AD4W3	Rivet	M13658	Qty	Part Number	Description	Batch	1	D2199-1	Strut	B19856	1	D2199-23	Strut	B12793/B11406/B10730	1	D2199-25	Strut	B12794	1	D2498	Mounting lug	B3924	1	D2499	Mounting lug	B1769	2	D2515	Bushing	B18029	1	D3052-1	Mounting lug	B18143	2	AN4-7A	Bolt	M14291	3	AN4-12A	Bolt	M13654	9	AN4-13A	Bolt	M14237	2	AN4-14A	Bolt	M13103	1	AN5-7A	Bolt	M5760	1	AN5-13A	Bolt	M13237	29	AN960JD416	Washer	M13719	3	AN960JD516	Washer	M13767	16	MS21042L4	Nut (or -4)	M13276	2	MS21042L5	Nut (or -5)	M5289	CP	04/03/02	1
Qty	Part Number	Description	Batch																																																																																																																																																																		
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2	AN960JD416L	Washer	M3154																																																																																																																																																																		
4	AN960JD516	Washer	M13767																																																																																																																																																																		
2	AN960JD8	Washer	M9636																																																																																																																																																																		
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4A - inspect hardware kit - 04/03/02 (1)
RR 04-OR 24 DR

RELEASED

DART AEROSPACE LTD	Work Order:	20305
Description: Heli-utility-basket, RH	Part Number:	D205-541-044
Drawing: D205-541 Rev. E	Qty:	1
		Page 2 of 2

Step	Location	Procedure	By	Date	Qty												
5	GA	Assemble as per Dwg D205-541 Attach Travellers: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D3053-042</td><td>Base</td><td>B20305</td></tr><tr><td>1</td><td>D2512</td><td>Lid</td><td>B20305</td></tr></table>	Qty	Part Number	Description	Batch	1	D3053-042	Base	B20305	1	D2512	Lid	B20305	ml	04.03.05	1
Qty	Part Number	Description	Batch														
1	D3053-042	Base	B20305														
1	D2512	Lid	B20305														
6	QC5	Inspect for foreign object per QSI 024 & Assembly work to Step 5	M	04/03/11	1												
7	PK	Box and identify as per PPP D205-541-044 Rev B	P	04.03.23	1												
8	AC	Cost / part: 1342.69 S4C	S4C	04.03.24	1												
9	DC	Close Work Order and Ensure Travellers Attached Inspect Level 21 / 1342.69 Travellers: D205-541-044 D3053-042 D2512	HJ	04.03.24	1												

Rev	Date	Change	Revised By	Approved
A	02.01.08	New issue	NG	
B	02.07.24	Re-format Location; Modify Step1, 5, 8 & 9	KJ	
C	02.08.30	Re-format Step 4 procedure column; CHG002	KJ RF	

RELEASED
02/09/03 RF

20305

D205-541-044

A

Page 1 of 2

of 01/03/02 1

RELEASED

DART AEROSPACE LTD	Work Order:	20305
Description: Heli-utility-basket, RH	Part Number:	D205-541-044
Drawing: D205-541 Rev. E	Qty:	1
		Page 2 of 2

Step	Location	Procedure	By	Date	Qty												
5	GA	Assemble as per Dwg D205-541 Attach Travellers: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D3053-042</td><td>Base</td><td>B20305</td></tr><tr><td>1</td><td>D2512</td><td>Lid</td><td>B20305</td></tr></table>	Qty	Part Number	Description	Batch	1	D3053-042	Base	B20305	1	D2512	Lid	B20305	ml	04-03-05	1
Qty	Part Number	Description	Batch														
1	D3053-042	Base	B20305														
1	D2512	Lid	B20305														
6	QC5	Inspect for foreign object per QSI 024 & Assembly work to Step 5	M	04/03/11	1												
7	PK	Box and identify as per PPP D205-541-044 REV B	(P)	04-03-23	1												
8	AC	Cost / part: 1342.69 S4C	S4C	04-03-24	1												
9	DC	Close Work Order and Ensure Travellers Attached Inspect Level 21 / 342.69 Travellers: D205-541-044 D3053-042 D2512	RF	04.03.29	1												

Rev	Date	Change	Revised By	Approved
A	02.01.08	New issue	NG	
B	02.07.24	Re-format Location; Modify Step1, 5; 8 & 9	KJ	
C	02.08.30	Re-format Step 4 procedure column; CHG002	KJ RF	RF

RELEASED
02/09/03 RF